

Date: Tuesday, 29/05/2007 10:53:48 AM
 User: Linda Lacelle

Process Sheet

Split 2 07-06-11

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT ASSEMBLY	
Job Number	: 32710-1		Part Number	: D3180041	
Estimate Number	: 10808		Drawing Number	: D3180-PRELIMINARY	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 29/05/2007	S.O. No. : <i>N/A</i>	Drawing Revision	: A	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 01/06/2007	
Previous Run	: 32328		Qty:	3 Um: Each	
Written By	: <i>J</i>				
Checked & Approved By	: <i>J</i>				
Comment	: Est Rev:A 03.01.27 New issue KJ/RF				

(PTO)

3
4 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	M304TR0750W049	304 RD Tube .750 x .049W			
		Comment: Qty.: 3.7625 f(s)/Unit Total : 3.7625 f(s) 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall (M304TR0.750W0.049) Batch: <i>M104565</i>		<i>45.000</i> <i>43.1</i>	<i>FF 07-05-29</i>
2.0	BRAKE NC	NC BRAKE			
		Comment: NC BRAKE			
		1-Punch 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall to length as per Dwg D3180 using DT8313 Ensure rotate and punch one end only as per view B-B as per Dwg. D3180			<i>FF 07-05-29</i>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1			
		Comment: SMALL & MEDIUM FAB RESOURCE 1			
		1-Drill Ø0.203" as per Dwg D3180			<i>FF 07-05-30</i>
		2-Bend one side only as per Dwg D3180 Identify as D3180-1			<i>FF 07-05-31</i>
		3-Deburr edges			<i>FF 07-05-30</i>
4.0	QC5	INSPECT WORK TO CURRENT STEP			
		Comment: INSPECT WORK TO CURRENT STEP			
		ENGINEERING APPROVAL			
					<i>07-05-30</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070611	16.0	Split two fl A Qty 1 on -2 split. 2 struts. to remain on this w/o.	J	0706-11	2	✓ 0706-11	✓ 0706-11

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 07/06/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-05-31	3	Ø0.20 HOLE IS POSITIONED AT 0.84 INSTEAD OF 0.75.	J 07-05-31 AS PEC 042 05-06-04	DEVIATION IS ACCEPTABLE.	SB 0705-31 0706-04	J 0706-04	X 07-05-31 AS PEC 042 05-06-04	✓ 0706-31

NOTE: Date & initial all entries

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Part Number: D3180041

Job Number:



Seq. #:	Machine Or Operation:	Description :	
5.0	POWDER COATING	POWDER COATING	<i>M10341</i> <i>P70</i> <i>3</i>
	Comment: POWDER COATING	Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	<i>BR</i> <i>07-05-31</i>
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	<i>M1</i> <i>3X</i> <i>07/06/04</i>
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
7.0	D2022101	Spacer	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Pick:		
	Qty Part Number Description Batch		
	2 D2022-101 Spacer	<i>B30543</i>	
8.0	D26906	Lanyard	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Pick:		
	Qty Part Number Description Batch		
	1 D2690-6 Lanyard	<i>B28519</i>	<i>①</i> <i>31191.</i>
9.0	A1449	Grommet	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
	Pick:		
	Qty Part Number Description Batch		
	1 D3180-1(ref) Strut	<i>B32710</i>	
	1 A1449 Grommet	<i>M1487.</i>	
10.0	AN960JD10	Washer	
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)		
	Pick:		
	Qty Part Number Description Batch		
	3 AN960JD10 Washer	<i>M10418</i>	<i>7/6/4 S9</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/04	S.0	2 struts have marker, marks on them, that came through the print.	QS1042	Grind to remove mark, then, clean with sand strut with 320. Clean part, re-painted coat per QS1005.	07-06-04 BL	07/06/04	QS1042	07/06/04

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Job Number: 32710		Part Number: D3180041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
11.0	BLRS001	Pip Pin
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick:		
Qty	Part Number	Description Batch
1	BLRS-001	Pip Pin <i>M15608</i>
12.0	MS21042L3	Nut
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick:		
Qty	Part Number	Description Batch
1	MS21042L3	Nut (or -3) <i>M10369</i>
13.0	MS27039110	Screw
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick:		
Qty	Part Number	Description Batch
1	MS27039-1-10	Screw <i>18836</i> <i>7/6/4 59</i>
14.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
1-Assemble as per Dwg D3180 <i>FF 07-06-04</i> <i>3</i>		
15.0	QC5	INSPECT WORK TO CURRENT STEP
		<i>2070605(3)</i>
Comment: INSPECT WORK TO CURRENT STEP		
<i>100-0028(3)</i>		
<i>Note: 1 out of 3 was sent to TRIX Helicopters for fit function purpose</i>		

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Job Number:



Seq. #: Machine Or Operation:

Description :

16.0 PACKAGING 1

PACKAGING RESOURCE #1



(P10)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

~~FOR ENGINEERING USE ONLY~~
07/6/28 (2)



17.0 QC21

FINAL INSPECTION/W/O RELEASE

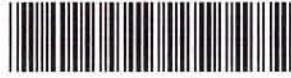


(2)

Comment: FINAL INSPECTION/W/O RELEASE

RDCR06/29

Job Completion



W 07.06.28

OK TO MANUFACTURE UP TO STEP 15,
DO NOT PASS STEP 15.

POSITIVE RECALL

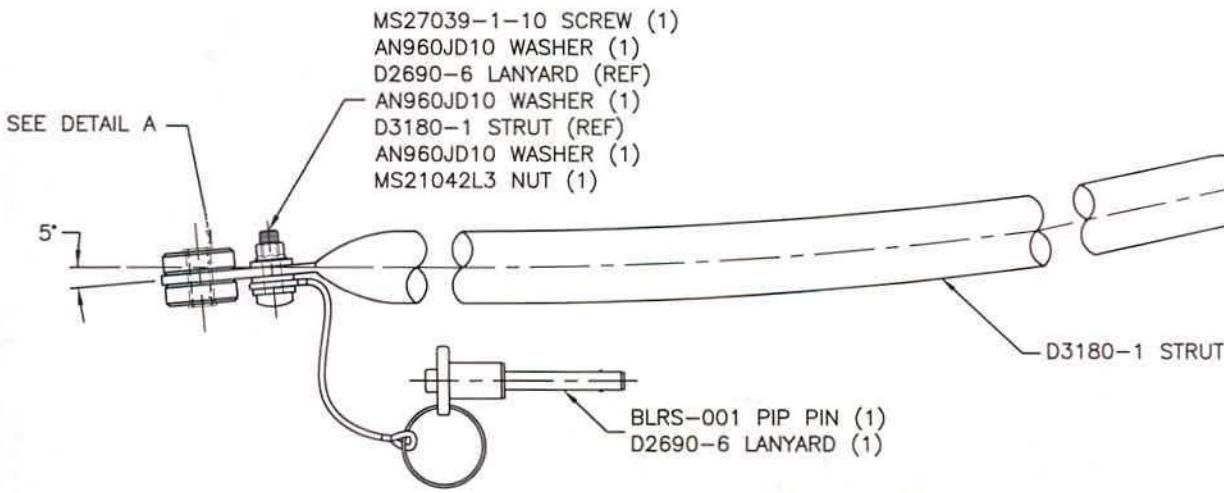
EFFECTIVE 07.06.31 AUTH Y

RELEASED 07.06.11 DATE 1

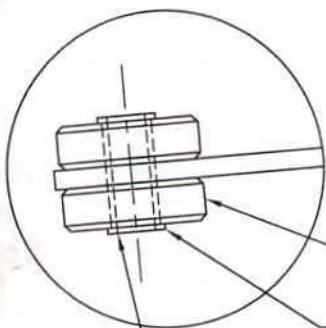
W

PRELIMINARY ISSUE

404.05.24

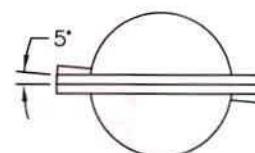


D3180-041 STRUT ASSEMBLY



DETAIL A

SCALE 1:1



VIEW B-B
SCALE 1:1

QTY -041	PART NUMBER	DESCRIPTION
X	D3180-041	STRUT ASSEMBLY
1	D3180-1	STRUT
1	D2690-6	LANYARD
2	D2022-101	SPACERS
3	AN960JD10	WASHER
1	MS27039-1-10	SCREW
1	BLRS-001	PIP PIN
1	MS21042L3	NUT
1	A1449	GROMMET

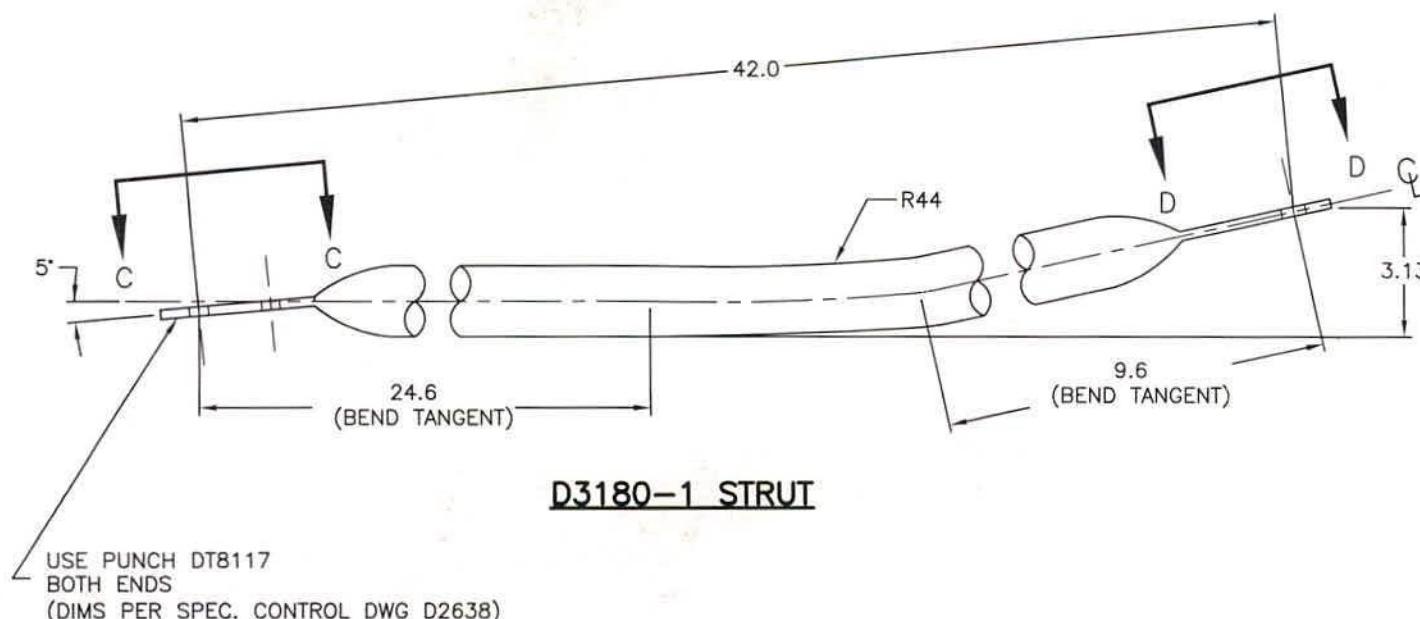
DESIGN #	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED	DRAWING NO. D3180
DATE 07.05.23		TITLE STRUT ASSEMBLY
A	03.01.06	NEW ISSUE
B	07.05.23	CURVE ADDED

PRELIMINARY ISSUE

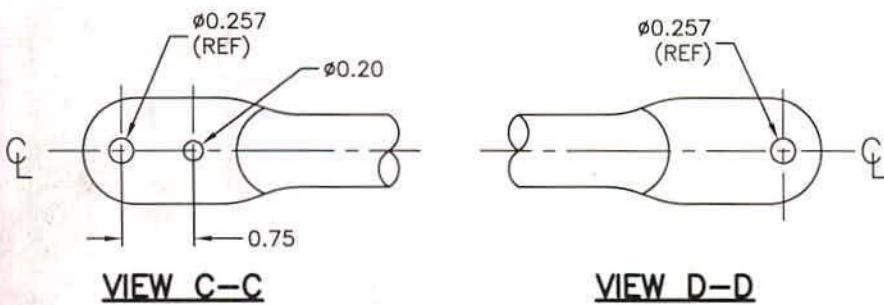
07.05.21

DESIGN <i>#</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED	DRAWING NO. D3180
DATE 07.05.23		TITLE STRUT ASSEMBLY

REV. B
SHEET 2 OF 2
SCALE
1:2



D3180-1 STRUT



NOTES

- 1) MATERIAL: AISI 304/316/318 SS TUBE,
Ø0.75 X 0.065 WALL
(REF. DART SPEC M304TR0.750W.065)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART
QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH PART P/N "D3180-041" USING
FINE POINT PERNAMENT INK MARKER